

(19) World Intellectual Property  
Organization  
International Bureau



(43) International Publication Date  
9 September 2005 (09.09.2005)

PCT

(10) International Publication Number  
**WO 2005/082559 A1**

(51) International Patent Classification<sup>7</sup>: **B21D 5/08**

(21) International Application Number:  
PCT/SE2005/000246

(22) International Filing Date: 23 February 2005 (23.02.2005)

(25) Filing Language: Swedish

(26) Publication Language: English

(30) Priority Data:  
0400485-9 27 February 2004 (27.02.2004) SE

(71) Applicant (for all designated States except US): **ORTIC AB** [SE/SE]; Tunavägen 290, S-781 73 Borlänge (SE).

(72) Inventor; and

(75) Inventor/Applicant (for US only): **INGVARSSON, Lars** [SE/SE]; Myntgatan 3, S-784 54 Borlänge (SE).

(74) Agent: **ÅSLUND, Roland**; Avesta Patentbyrå, P.O. Box 99, S-775 26 Krylbo (SE).

(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM,

AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

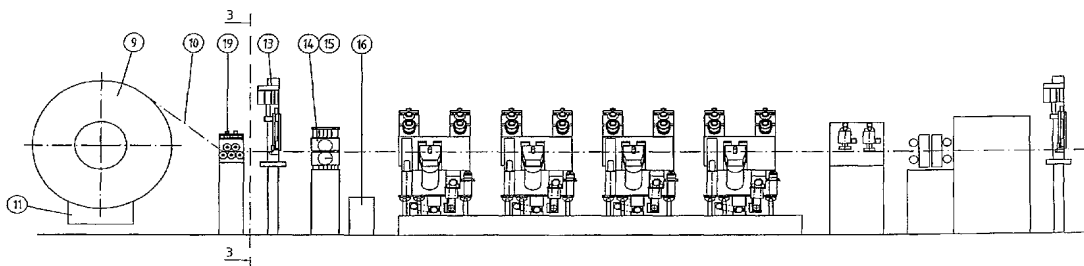
(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

**Published:**

- with international search report
- before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(54) Title: A PRODUCTION LINE AND A METHOD OF FORMING PROFILES



(57) Abstract: Profiles (50) are formed in a production line with a cross-section that varies along their length from a plane metal strip (10) that is unwound from a coil (9), whereby edge cutters (14) and a number of roll-forming units (17-24) are used where not only the edge cutters but also the roll-forming units can be displaced individually sideways relative to the strip. The edge cutters (14) and the roll-forming units (17-24) are individually controlled such that they follow the lines of extent of the side edges (51, 52) that are cut and the lines of the corners (53-56) that are subsequently formed, and the forming of one corner with a number of roll-forming units is started only after the forming of a corner that lies more closely to the edge of the strip has been completed. The formed profile is bent in a bending station integrated into the line, which bending station comprises rollers (35-40) that can be controlled to roll sections of the profile (50) to become thinner such that the profile is bent or twisted as it is formed.

WO 2005/082559 A1